Work Orde Friday, October				*(9232	7*							Page 1
Item ID: Revision ID: Item Name:	D412-709-01 Escape Panel I		*N900040100* Setup St. St							Start Stop	*N:	S1*	
Start Date: Required Date: Reference:	10/26/2012 10/26/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*			Cust Item I Customer:	D:						
Approvals:	Process Pla	in: MM	Date: 12/10/2	Dooling:			ate:			Run	Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set U _l Run F		Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr					··						
IIN-D412-709	Rev	C	Λ .										
1 \\n DC Document Control		DOCUMENT CONTRO Memo Photocopy	DL Signal DL bluefile & type labels per	0.00 0.00 PPPD412-709-(16 2-85 011 CHG001	Alula V		·			MC	5 12	-10-29
	90 J		5 건									,	
110		Pick Kit		0.00		÷						. 1	
110 Packaging Packaging		Memo		0.00					··			12/	10/0/04
					0 A .								Or
120		QC4- 100% Inspect kits	for completeness	0.00	16	12/10/30							
120 QC Quality Control		Memo		0.00		· 4				,			

										DQA:	Date	
NCR:	Yes / No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE	ı			
			4	**						QA Closed:	Date	
Work Orde	ar:	,			DISPOSITION	Í		AGAINST	DE	PARTMENT	PROCESS	
WORK OTCK					Rework	۱ ۲		Skid-tube Crosstube			Water Jet	Engineering
Part N	No.				Scrap	1	B	Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
				:	Use-as-is	1		noforming Finishing	_	†	e/Packaging	Other
NCR N	No.				Work Order Update	1		Large Fab Composite	-	•	Supplier	1
						_						
Root				Descri	ption of work order update	T	Initial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data			1									
Equip/Tooling	•									-		
Operator												
Material								-				
Setup												
Other												
Process								•				
Supplier				ş.	•		-	*				
Training												
Unapproved		<u> </u>	1							<u> </u>		
	· · · · · · · · · · · · · · · · · · ·					AUI	LT CATE	GORY		·		
Landi	ng Gear			_	General	_	1	•		1		¬_
	Bending				Bend	Ŀ	Grain		<u>_</u>	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S				BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under	-	Temperature/Cure
	Cracks				Broken/Damaged	_	Inspection Incomplete			Part Incorre	<u> </u>	Weld
	Crushed/Crimped				Burrs	_	Instructions Incomplete/Unclear			Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	_	Mainte		Part Moved			
	Heat Tre	at		- 1	Countersink	ntersink Mislabeled Mislabeled			1	Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord Friday, Octobe				*92327*								Page
Item ID: Revision ID:	11			Accept	*N900	040	100)* s	Setup Star	ı	S1*	
Item Name:	Escape Panel	Modification								Sto	*N	S2*
Start Date:	10/26/2012	Start Qty: 1.00		*1*		Cust Item 1	D:					
Required Date	e: 10/26/2012	Req'd Qty: 1.00		*1*		Customer:						
Reference:				•								
Approvals:	Process Pla	ın:	Date:		Tooling:	D:	ate:	-	F	Run Stai	^{rt} *N	R1*
	QC:	QC:			SPC (Y/N):	Date:				Sto	*N	R2*
Sequence ID/ Work Center	ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130					0.00							1
130		Packaging									DI1	,208/<
Packaging		Memo			0.00							

140

Packaging

QC21- Final Inspection - Work Order Release

Location:

0.00

140

Quality Control

Memo

Identify and pack for shipping as per PPP D412-709-011

0.00

MCS 12-10-30

Page 2

NCR:	Yes	1	No

											DQA:	Date:	
NCR:	Yes	, No					WORK ORDER NON-C	O	NFORM	MANCE / UPDATE			
							_				QA Closed:	Date:	
Vork Ord	er.						DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
voik ora	٠,٠.						Rework	1		Skid-tube Crosstube	1	Water Jet	Engineering
Part	No.						Scrap Machining Small Fab			Pro	d. Eng. Coor.	Quality	
	•						` 			noforming Finishing	4	e/Packaging	Other
NCR No.							Work Order Update			Large Fab Composite		Supplier	
								لـــا					
Root					Desc		otion of work order update	ı	nitial	Action	Sign &		
Cause	_	Date	Step	Qty		С	r Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector
oc/Data	Ш												
uip/Tooling	-												·
perator													
aterial	Н						·						
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ipplier	\vdash								5				
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napproved				L	L			<u> </u>	T CATE	GORY	1		1
Land	ng (iear					General		CATE				
		Bending			ſ		Bend		Grain		Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to	o/s		BOM/Route		Hardwa	are	Over/Under	tolerance	Temperature/Cure
		Cracks			İ		Broken/Damaged		Inspecti	ion Incomplete	Part Incorre	ct	Weld
		Crushed/0	Crimped.		Ī		Burrs		Instruct	tions Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs Contamination						Contamination		Mainte	enance	Part Moved		_
	Heat Treat Countersink						Countersink		Mislabe	eled	Positioned V	Vrong	_
		Inspection	n Strip in	Tube			Cut Too Short		Misread	d	Power Loss/	Surge	Other
	Ripples in Bend Drill Holes						Drill Holes		Offset				
•	Torque Waves in Extrusion Drawing						Drawing	Out of Calibration					
		Turning Se	equence		Ī		Finish		Out of 9	Sequence			
•	Wave/Twist in Tube Folio						Folio		Outside Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

92327

Parent Item:

D412-709-011

Parent Item Name:

Escape Panel Modification

Comments:

IPP Rev:B Removed Manufacturing

IPP rev C removed sub-components

07.11.12 EC

05-11-06 JLM

Start Qty: 1.00

Start Date: 10/26/2012

Required Date: 10/26/2012

Required Qty: 1.00

IPP Rev:D 10.05.20 added D3561-1 DD verf:EC

	DD Ven.ec								·
Component Item Item Name	ID/ Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit Total Qty Date Status Qty Issued Issued
AN6-20A Bolt		Purchased	No			110	Each	23.0000	35 S
S		l		Location		Loc Qty	L	oc Code	
				ST339	116	20 20			
				ST341	706	3			2 .
Washer	/NAS1149D0332J	Purchased	No			110	Each	0.0000	2 MI22973 AD SA
Washer——	NAS1149D0663J	Purchased	No			110	Each	0.0000	5 M123021 S) (8)
AN960JD616L Washer	NASI17d Doplet	 Purchased 	No			110	Each	0.0000	5 M120418 P
D3118-3 Sign Assembly		Manufactured	No			110	Each	0.0000	1 923365
Frame		Manufactured	No			110	Each	4.0000	1 5 3
				Location ST218		Loc Oty	<u>L</u>	oc Code	
(5) D3239-1. Cover		Manufactured	No	8674	2	110	Each	13.0000	(2) 2 SD 85
				<u>Location</u>		Loc Qty	<u>L</u>	oc Code	
D412-709-013 C Escape Panel Push O	LYCOW \ Lycom	Manufactured	No	ST035	5	. 13 . 13	Each	0.0000	1 92328 SJ &

									DQA:	Date:	
NCR: Ye	s / No			WORK C	RDER NON-C	ONFOR	MANCE / UI	PDATE	QA Closed:	Date:	
Work Order:	:	,		DIS	POSITION			AGAINST D	EPARTMENT,	/PROCESS	
Part No).			 Work (Rework Scrap Use-as-is Order Update	1 1	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Description of work	order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty	or Non-confo	or Non-conformance			cription	Date	Verification	QC Inspector
Doc/Data							,				
quip/Tooling											
Operator		<u> </u>]			•		
Material	_	i I								٠.	
Setup											
Other			•								•
rocess											
Supplier		}									
Fraining	_				**						,
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<u> </u>					F	AULT CATE	GORY				
Landing	g Gear			Ge	neral				_		٦
	Rending			Rend		Grain		1	Ovalized	j	Pressure/Forced

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

BOM/Route

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish Folio

Burrs

Broken/Damaged

Over/Under tolerance

Part Incorrect

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Temperature/Cure

Wrong Stock Pulled

Weld

Other

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

Friday, October 26, 2012 3:22:38 PM

Work Order ID: 92327 Parent Item: D412-709-011 **Start Date: 10/26/2012 Required Date:** 10/26/2012 **Escape Panel Modification** Parent Item Name: Required Qty: 1.00 Start Qty: 1.00 MS21042D3 No 110 Each Purchased 3,019.0000 Location Loc Qty Loc Code 316 627 122452 627 ST300 338 117885 32 119017 168 119075 138 ST314 1628 123265 1628 ST317 426 122141 426 MS210421/6 No 110 Purchased Each 1,045.0000 **Location** Loc Qty Loc Code 314 266 122441 266 ST300 279 117677 25 118384 3 118927 48 119075 4 120308 199 ST314 500 123248 350 123355 150 No Purchased 110 Each 262.0000 Screw Location Loc Qty Loc Code ST295 262 162 115016 121014 100

									DQA:	Date:					
NCR: Ye	s / No				WORK ORDER NON-C	ONFORI	MANCE / UP		QA Closed:	Date:					
Work Order					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No	·				Rework Skid-tube Crosstube Scrap Machining Small Fab Thermoforming Finishing Work Order Update Large Fab Composite			Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
Root				Descri	Lption of work order update	Initial	Ad	ction	Sign &						
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	ng Description		Date	Verification	QC Inspector				
Doc/Data [quip/Tooling															
Operator								•							
Material	_														
Setup	_														
Other	_														
Process	1	ł	1							I					

Landir	Landing Gear		General		_	_	
	Bending		Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S		BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks		Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped		Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Г	Contamination		Maintenance	Part Moved	
	Heat Treat		Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube		Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend		Drill Holes		Offset		
• [Torque Waves in Extrusion		Drawing		Out of Calibration		
	Turning Sequence	Г	Finish	Г	Out of Sequence		
•	Wave/Twist in Tube		Folio	Г	Outside Dimensions		

FAULT CATEGORY

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Supplier Training Unapproved



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5.0 PARTS LIST

Qty- -011-	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X	-010	-0.0	-017		<u> </u>	020	₽412-709-011	ESCAPE PANEL MODIFICATION KIT
4	x						-D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		Х					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
	-	1	Х			<u> </u>	D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				Х			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					Х		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	Х	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			1				D2126-0720	LOCKING SEAL
11	-						D3118-3	'SIGN ASSEMBLY
*			The seconds	1			D3136-041	WINDOW ASSEMBLY
	_1						D3136-043	WINDOW ASSEMBLY
1							D3224-1	FRAME
			1				-D3236=1	WINDOW
						1	D3237-1-0720	SEAL RETAINER
	1			1		<u> </u>	D3237-1-0980	SEAL RETAINER
-				· · · · · ·		1	D3237-3-0720	SEAL FILLER
	1			1		<u> </u>	D3237-3-0980	SEAL FILLER
7-2		1					D3239-1 /	COVER
		1				<u> </u>	D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
	1	· · · · · · · · · · · · · · · · · · ·		1		1	D3561-1	WINDOW SEAL TOOL
/ 3					-	10.00	AN6-20A	BOLT
/ 2							AN960JD10L	WASHER
5	-						AN960JD616-	_WASHER
5 5						1	AN960JD616L	WASHER
2							MS21042L3	-NUT
7 3	Na (200)						MS21042L6	NUT
7 2							MS35207-262	SCREW?
	J4.1.07							
			L				1	

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Revision: C

Date: 06.11.27

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